

4/30/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

004315



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-4-OH
Job Sheet 176763



Part No: SWA6A-4-OH

Job Qty: 1 ea

Part Name: Electric Swivel 6,000 lb Safe Work Load (2,721 kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/30/18

Job Tracking No: RA150 SN: AC09001

Due Date: 5/14/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG SWA6A Rev. 4 IPP Rev. A 18.04.27 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	5/14/18	5/14/18	0.00	0.00	Start Up Small Fab-4		18-06-04 CB
110	Small Fab	1 pcs	5/14/18	5/14/18	0.00	1.00	Small Fab-9		AP
120	QC	1 pcs	5/14/18	5/14/18	0.00	0.00	QC5		SB
130	Customer Acceptance	1 pcs	5/14/18	5/14/18	0.00	0.00			
140	Outsource	1 pcs	5/14/18	5/14/18			SKY002-VC	40060	JUN 04 2018
150	Packaging	1 pcs	5/14/18	5/14/18	0.00	0.00	Packaging2		AP 10/6/06
160	QC	1 pcs	5/14/18	5/14/18	0.00	0.00	QC6		38
170	Small Fab	1 pcs	5/14/18	5/14/18	0.00	1.00	Small Fab-9		9-89 AP
180	QC	1 pcs	5/14/18	5/14/18	0.00	0.00	QC5		SB
185	DC	1 pcs	5/14/18	5/14/18	0.00	0.00	DC		N/A
190	Packaging	1 pcs	5/14/18	5/14/18	0.00	0.00	Packaging3-2		21
200	QC21-FG	1 Ea	5/14/18	5/14/18	0.00	0.00	QC21		JUL 11 2018

Part Op 110 - RA: TEST ASSEMBLY. DISASSEMBLE ASSEMBLY. INSPECT DAMAGE PART

Descriptions: 170 - RE-ASSEMBLE. ***All assembly to be done in accordance with manual*** TEST ASSEMBLY.

185 - Photocopy blue file O&OPM-SWA6A Rev.2

GREASE AEROSHELL No.7 (M138724)
LOCTITE 242 (M138762)
SILICONE G.E (M138883)



Container No: S077714



Part: SWA6A-4

Job No: 176763

Serial No/Batch: S077714

Revision: 4

Inspector:

Exp Date: 06/04/2018

Instructions:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 813 632-6200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 06/04/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA6A-4-AR	Electric Swivel 6,000 lb Safe Work Load (2,721 Kg)	1 Ea (1 ea)	100-Start up Operation	
188-FPSS-1032-1/2	Set Screw	1 Ea (1 ea)	170-Small Fab	5037670
188-FSCS-1032-5/8	Screw	4 Ea (4 ea)	170-Small Fab	5062752
C45-15-13	Sleeve	1 Ea (1 ea)	170-Small Fab	5089116
EL414-ARTIC	4 Wire	6 ft (6 ea)	170-Small Fab	5047764
SWA6A-100	Lower End	1 Ea (1 ea)	170-Small Fab	
SWA6A-1100	Upper Bearing	1 Ea (1 ea)	170-Small Fab	5070133
SWA6A-1200	Lower DU Bearing	1 Ea (1 ea)	170-Small Fab	5044605
SWA6A-1300	Lower Thrust Bearing	1 Ea (1 ea)	170-Small Fab	5043315
SWA6A-1400	Circlip Internal	1 Ea (1 ea)	170-Small Fab	5045017
SWA6A-1800	Cover	1 Ea (1 ea)	170-Small Fab	
SWA6A-1900	Female Spade Terminal - 1/4"	4 Ea (4 ea)	170-Small Fab	5054299
SWA6A-200	Upper End	1 Ea (1 ea)	170-Small Fab	
SWA6A-2000	1/8" Female Spade Connector	4 Ea (4 ea)	170-Small Fab	5047604
SWA6A-300	Bearing Housing	1 Ea (1 ea)	170-Small Fab	
SWA6A-400	Thrust Washer	1 Ea (1 ea)	170-Small Fab	5035446
SWA6A-500	Semi Rings	1 Ea (1 ea)	170-Small Fab	
SWA6A-600	Collar	1 Ea (1 ea)	170-Small Fab	
SWA6A-700A	Wire Clamp	2 Ea (2 ea)	170-Small Fab	5051701
SWA6A-800B	Connector Bushing	1 Ea (1 ea)	170-Small Fab	
SWA6A-900C	Rotary Contact	1 pos (1 ea)	170-Small Fab	
2856 K75 SHRWK TUBE				5048885

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	SWA6A-4	1	0	0
170-Small Fab	188-FPSS-1032-1/2	1	86	0
	188-FSCS-1032-5/8	4	257	0
	C45-15-13	1	6	0
	EL414-ARTIC	6	347	0
	SWA6A-100	1	2	0
	SWA6A-1100	1	0	0
	SWA6A-1200	1	30	0
	SWA6A-1300	1	11	0
	SWA6A-1400	1	20	0
	SWA6A-1800	1	0	0
	SWA6A-1900	4	272	0
	SWA6A-200	1	1	0
	SWA6A-2000	4	148	0
	SWA6A-300	1	0	0
	SWA6A-400	1	1	0
	SWA6A-500	1	1	0
	SWA6A-600	1	1	0
	SWA6A-700A	2	8	0
	SWA6A-800B	1	0	0
	SWA6A-900C	1	0	0

Part Specifications

Specifications could not be found.

Plex 4/30/18 2:36 PM Dart.Gagnon.Michelle

Inspection Sheet Complete RA150

Customer QA Ref #

0

Part Number	Batch / Serial #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Work order #	Work order instructions
C60	SN 6071, M994-03	2	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S041605(6071); and S052546(M994-03)	Customer supplied part. Customer sending C60 SN 6071 to be overhaul. Perform overhaul and return to customer. Customer also sending C60 M994-03 to be overhaul. C60 was received with cage. Remove from cage, perform overhaul, re-install hook to cage and return to customer.
C45	AC11007	1	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S050438	Customer supplied part. Customer sending C45 AC11007 to be overhaul. C60 was received with cage. Remove from cage, perform overhaul, re-install hook to cage and return to customer.
SWA6A-2	AC10006, AC11003, AC4006,	3	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S041058(AC10006); S041604(AC11003); S042053(AC4006)	Customer supplied part x3. Customer sending SWA6A-2 AC4006, AC11003 and AC4006 to be overhaul. Perform overhaul and return to customer.
SWA6A-4	AC09002 AC09001	2	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S041603(AC09002) and S061865(AC09001)	Customer supplied part x2. Customer sending SWA6A-4 serial# AC09002 and AC09001 for testing. Perform test as per Electric Swivel SWA6A. Return to customer.
P5400-100	AC09003	1	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S052552(AC09003)	Customer supplied part. Customer sending longline P5400-100 serial# AV09003 for inspection Send out for pull test. Return to customer.
P5400-50	AC09002	1	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S041056(AC09002)	Customer supplied part. Customer sending longline P5400-50 serial# AV09002 for inspection Send out for pull test. Return to customer.
P7300-150	BMMG722	1	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S050439(BMMG722)	Customer supplied part. Customer sending longline P7300-150 serial# BMMG722 for inspection Send out for pull test. Return to customer.
P7300-50	AC09001, AC09002	2	☐ es	☐ es	☐ es	☐ es	CUSTOMER SUPPLIED	S041057(AC09001) and S052555(AC09002)	Customer supplied part. Customer sending qty2 of longlines P7300-50 serial# AC09001 and AC09002 for inspection Send out for pull test. Return to customer.

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Suspected Unapproved ☐		Large Fab ☐		Composite ☐	Supplier ☐				
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							

C2-6HC	AC09001, AC09002	2	☐ yes	☐ yes	☐ yes	☐ yes	CUSTOMER SUPPLIED	S061883(AC9001) and S061884(AC09002)	Customer supplied part qty 2. 1.Customer sending C2-6HC serial# AC09001 for overhaul. Carousel C2-6HC was received with all C2 hook install serial# M987-07, M987-10, M987-11, M987-12, M987-13, and M987-14 Disassemble and perform overhaul on carousel and all C2 hook as per manual and record all finding as per test sheet. Reinstall and return to customer. 2.Customer sending C2-6HC serial# AC09002 for overhaul. Carousel C2-6HC was received with all C2 hook install serial# M987-09, M987-16, M987-17, M987-18, M987-20, and M987-22 Disassemble and perform overhaul on carousel and all C2 hook as per manual and record all finding as per test sheet. Reinstall and return to customer
C2(These Hooks are part of C2-6HC above)		12	☐ yes	☐ yes	☐ yes	☐ yes			See C2-6 HC above
			☐ yes	☐ yes	☐ yes	☐ yes			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

PRE-TEST



Electric Swivel
SWA6A

Work Order 176763

Customer _____

Number of Wires 4

Date 2018/05/03

Serial Number AC09001

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	6,000	Check for Conductivity against all wires.	- PASS
1	6,000	Check all wires for grounding against swivel body.	- PASS
1	3,000	Check for Conductivity against all wires.	- PASS
1	3,000	Check all wires for grounding against swivel body.	- PASS
1	1,500	Check for Conductivity against all wires.	- PASS
1	1,500	Check all wires for grounding against swivel body.	- PASS
1	0	Check for Conductivity against all wires.	- PASS
1	0	Check all wires for grounding against swivel body.	- PASS

Test Conducted By: ALAIN PATRY

Signature: _____

Technician

QC 5 Small FAB / QA

Submit



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040060**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO040060
PO Date: 5/31/18
Due Date: 6/4/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176290	C60-OH	C-Series Remote Hook 6,000 lbs Lift Capacity	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00
2	176761	C45-OH	C-Series Remote Hook 4,500 lbs Lift Capacity	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00
3	177397	C45-K-OH	C-Series Remote Hook 4,500 lbs Lift Capacity - Keeperless	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00
4	176292	SWA6A-2-OH	Electric Swivel 6,000 lb Safe Work Load (2,721 kg)	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00
5	176763	SWA6A-4-OH	Electric Swivel 6,000 lb Safe Work Load (2,721 kg)	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00
6	177593	SWA6A-3-OH	Electric Swivel 6,000 lb Safe Work Load (2,721 kg)	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00
7	177594	SWA6A-3-OH	Electric Swivel 6,000 lb Safe Work Load (2,721 kg)	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00
8	171614	C10-OH	C-Series Remote Hook 10,000 lbs Lift Capacity	Firmed	6/4/18	1 pcs	0 pcs 1x	1 pcs	\$178.00/pcs	\$178.00

Grand Total: \$1,424.00

Order Notes

cor'd 11/06/06



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO36235	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO040060
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

2 ELECTRIC SWIVEL, P/N# SWA6A-3-OH , J/S# 177593 , 177594

1 ELECTRIC SWIVEL, P/N# SWA6A-2-OH , J/S# 176292

1 ELECTRIC SWIVEL, P/N# SWA6A-4-OH , J/S# 176763

1 C-SERIES REMOTE HOOK , P/N# C45-K-OH , J/S# 177397

1 C-SERIES REMOTE HOOK , P/N# C45-OH , J/S# 176761

1 C-SERIES REMOTE HOOK , P/N# C60-OH , J/S# 176290

1 C-SERIES REMOTE HOOK , P/N# C10-OH , J/S# 171614

Action Taken:	Date:	Initial/Stamp:				
LPI & MPI C/O IAW ASTM E-1417M-16 & E-1444M-16 ***NO CRACK FOUND*** MAGBENCH S/N 208123 CAL DUE: 23-JUL-2018 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO20165 PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142	JUN 01 2018	  DAS 38 9-89				
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELKIAN		JUN 01 2018

Work Order

176763

Customer

Number of Wires

4

Date

2018/07/10

Serial Number

S077714

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	6,000	Check for Conductivity against all wires.	- PASS
1	6,000	Check all wires for grounding against swivel body.	- PASS
1	3,000	Check for Conductivity against all wires.	- PASS
1	3,000	Check all wires for grounding against swivel body.	- PASS
1	1,500	Check for Conductivity against all wires.	- PASS
1	1,500	Check all wires for grounding against swivel body.	- PASS
1	0	Check for Conductivity against all wires.	- PASS
1	0	Check all wires for grounding against swivel body.	- PASS

Test Conducted By:

ALAN PATRY

Technician

Signature:

Sylvie Pouchet
QC 5 Small FAB / QA